

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006221**Date Inspected:** 06-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1030**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Japan Steel Works**Location:** Muroran, Japan**CWI Name:** Chung Fu Kuan**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower, Jacking and Deviation Saddles**Summary of Items Observed:**

On this date, 4/6/09, Caltrans OSM Quality Assurance (QA) Inspector Mike Brcic was present during the times noted above for observations relative to the work being performed on castings, in either the Fabrication shop #4 or Foundry Shop at Japan Steel Works.

W2E3 - Casting section idle, built up section has apparently had bevel preparation completed.

W2W2 - Magnetic Particle testing (MT) technician, Mr H. Kohama, was in process of conducting Wet Magnetic Particle testing of casted/shaped/blasted Level 1 areas, approximately 85% of the external areas complete, (trough area yet to be started).

W2W3 - Casting has returned from Post Weld Heat Treat (PWHT), repair welds will now require excess reinforcement be removed.

T1-2 - Welders 08-5153, 92-2439, and 81-5438 were beginning welding of joints 8Y-5U1, 8Y-5U-3, and 8Y-8U respectively. QCI verified amperes and preheat of welders, parameters were found to be in compliance to procedure SJ3012-5, contract documents and special provisions.

T1-3 - Buttering procedure SJ3012-1-1 was being met by welders # 07-2941, 07-4510, and 07-4528, while surfacing joints 9Y-12U-2 (2nd layer), 9Y-5U-2 (3rd layer), and 9Y-10U (1st layer) respectively, all parameters set forth contract by documents and special provisions appeared to be met at this time.

E2E1 - Two men actively shaping by way of Carbon Arc, appears to be 80% complete.

E2W1 - Two men actively grinding the remaining 'Carbon Arc' surfaces.

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Unless otherwise noted, all observations reported on this date appeared to be in general compliance with applicable contract documents.

Summary of Conversations:

No significant conversations to report on this day.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, 1(510)385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Brcic,Michael	Quality Assurance Inspector
Reviewed By:	Lanz,Joe	QA Reviewer
